

SHIP JUNE 12~~4~~

Work Order ID 133164

133164

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Tuesday, May 26, 2015 12:49:19 PM

Item ID: D119-796-021 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/04/15 Start Qty: 1.00 *1*

Required Date: 6/24/15 Req'd Qty: 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  Date: 5.5.26 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D119-796	REV A								
100	Pick Kit	0.00							MLJ JUN 17 2015
100									
Packaging	Memo	0.00							
Packaging	Photocopy bluefile and create labels as per PPP D119-796-021 chg 001								
110		0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	ASSEMBLE AS PER DWG AND NOTES 8,9,10,11								
	2-INSTALL DECAL D2729-4								
	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

① SAD 15/06/17

 15/06/17

① 15-06-17

DAS 9 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 133164***133164***

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Item ID: D119-796-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/04/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/24/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-021								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

① MS-6-17ML5 JUN 17 2015MS-6-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																					

Picklist Print

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Work Order ID: 133164

133164

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/04/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP-REV:A NEW ISSUE 15-05-012 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-041		Manufactured	No				Each	0.0000		①			
D119-646-041									**	1 5-6-9			
Replacement Skidtube with Wearpads, Fits LH or RH													
D119-796-151		Manufactured	No				Each	0.0000		1			
D119-796-151									**	SAD 15-06-09			
FWD Crosstube Installation with Step (no hardware)													
D119-796-251		Manufactured	No				Each	0.0000		1			
D119-796-251									**	1 5-6-17			
AFT Crosstube Installation with Step (no hardware)													
D2652		Manufactured	No				Each	332.0000		48			
D2652									**				

D2652

Bushing

Location	Loc Qty	Loc Code
FG	45	
31985	45	
ST009	150	
129993	50	
131928	100	
ST012a	137	
123711	32	B1327D
124422	2	
129992	0	
131087	103	

DAE
27
JUN 28 2015

48

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, May 26, 2015 12:49:10 PM

Work Order ID: 133164

133164

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/04/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

D3407-041

Manufactured No

Each 6.0000 2

D3407-041

Tow Ring

~~DA~~
27
9-89

Location

Loc Qty

Loc Code

st530

1

128380

1

ST532

5

107840

3

119184

2

Each 78.0000

4

~~DA~~
27
9-89

Location

Loc Qty

Loc Code

ST038

1

124382

1

ST038A

77

129948

35

131054

42

Each 83.0000

2

~~DA~~
27
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST051A

76

128456

3

130974

50

132585

23

B133136

JUN 08 2015

D3417-5

Manufactured No

D3417-5

Washer

Location

Loc Qty

Loc Code

ST038

1

124382

1

ST038A

77

129948

35

131054

42

Each 83.0000

2

~~DA~~
27
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST051A

76

128456

3

130974

50

132585

23

B133136

JUN 08 2015

D3456-1

Manufactured No

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST051A

76

128456

3

130974

50

132585

23

B133136

JUN 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, May 26, 2015 12:49:12 PM

Work Order ID: 133164

133164

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/04/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

Each

763.0000

48

D3672-3******

Washer, Phenolic

LocationLoc QtyLoc Code

FG

119

127875

83

129916

21

84432

11

89273

4

FP001

514

107316

14

132639

500

ST055

130

129916

130

Each

365.0000

48

D3672-7

Manufactured No

D3672-7******

Washer, Phenolic

LocationLoc QtyLoc Code

FG

18

120476

18

ST055

347

120476

6

129987

341

Each

6.0000

2

D3883-1

Manufactured No

D3883-1******

Saddle, Outboard LH

LocationLoc QtyLoc Code

ST404

6

128747

2

129064

4

2

DAG
27
9-89DAG
27
9-89DAG
27
JUN 8 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																																		
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Root Cause				FAULT CATEGORY																																																																					
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OTHER : ☐																																																																									

Picklist Print

Tuesday, May 26, 2015 12:49:13 PM

Work Order ID: 133164

133164

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/04/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

D3883-2 Manufactured No

Each 14.0000 2

D3883-2

Saddle, Outboard RH

Location

Loc Qty

Loc Code

ST404

14

127748

2

129065

12

Each

6.0000

2

DA0

27

9-89

D3884-1 Manufactured No

D3884-1

Saddle, Inboard LH

Location

Loc Qty

Loc Code

ST404

6

129066

6

Each

17.0000

2

DA0

27

9-89

D3884-2 Manufactured No

D3884-2

Saddle, Inboard RH

Location

Loc Qty

Loc Code

ST404

17

127624

6

129067

10

129415

1

Each

18.0000

4

DA0

27

9-89

D3886-041 Manufactured No

D3886-041

Lug Assembly

Location

Loc Qty

Loc Code

st529

18

124454

8

130027

2

130512

8

DA0

27

9-89

JUN 0 8 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Tuesday, May 26, 2015 12:49:15 PM

Work Order ID: 133164

133164

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/04/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

AN3C46A Purchased No

Each 293.0000 8

AN3C46A

Bolt

**

DA

27

JUN 08 2015

Location

Loc Qty

Loc Code

FG	10	
122843	10	
FP001	8	
M128491	8	
ST338a	171	
131651	70	
M131856	31	
M132169	70	
ST346	104	
M130796	12	
M131367	22	
M132381	70	

M132381

9

AN3C50A Purchased No

Each 124.0000 16

AN3C50A

Bolt

**

DA

27

8-09

JUN 08 2015

Location

Loc Qty

Loc Code

ST338a	96	
131651	24	
M131367	24	
M132169	24	
<u>M132381</u>	24	
ST346	28	
M128491	16	
M131263	4	
<u>M131856</u>	8	

9

87

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Page 6

Tuesday, May 26, 2015 12:49:17 PM

Work Order ID: 133164

133164

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/04/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

Each

415.0000

24

AN4C6A

DAS

Bolt

27

990

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

ST312A

149

m131618

149

ST345

252

m130716

52

m131410

200

Each

833.0000

24

MS21043-3

Purchased

No

MS21043-3

DAS

Nut

27

JUN 8 2015

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

41

m130673

41

GA

281

m130673

15

m131677

266

ST304

431

m131340

231

m132382

200

Tuesday, May 26, 2015 12:49:18 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Picklist Print

Tuesday, May 26, 2015 12:49:18 PM

Page 7

Work Order ID: 133164

133164

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/04/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

Each

918.0000

26

~~DAS~~

~~27~~

~~9-89~~

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

285

m128798

285

ST304

593

m128818

34

m131697

59

m132382

500

26

MS21043-5

Purchased

No

Each

394.0000

8

~~DAS~~

~~27~~

~~9-89~~

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

77

116548

77

ST304

297

m132123

97

m132382

200

8

MS21250-05048

Purchased

No

Each

41.0000

8

~~DAS~~

~~27~~

~~9-89~~

MS21250-05048

BOLT

Location

Loc Qty

Loc Code

ST298

41

m132317

41

8

JUN 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :									
Misidentified ☐	Past Due ☐										

Picklist Print

Tuesday, May 26, 2015 12:49:18 PM

Work Order ID: 133164

133164

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/04/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each

6,705.000

24

NAS1149C0332R

DAS
27
9-89

WASHER

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

442

m131618

442

ST260a

16

m131697

16

ST271

4107

m132262

4107

24

NAS1149C0432R

Purchased

No

Each

2,633.000

48

NAS1149C0432R

DAS
27
9-89

WASHER

Location

Loc Qty

Loc Code

GA

2068

m125807

476

m131467

1592

ST271

565

m131452

565

48

NAS1149C0532R

Purchased

No

Each

308.0000

16

NAS1149C0532R

DAS
27
9-89

WASHER

Location

Loc Qty

Loc Code

GA

62

116513

62

ST271

246

m128537

46

m131624

200

14

JUN 0 8 2015

DQA: _____ Date: _____



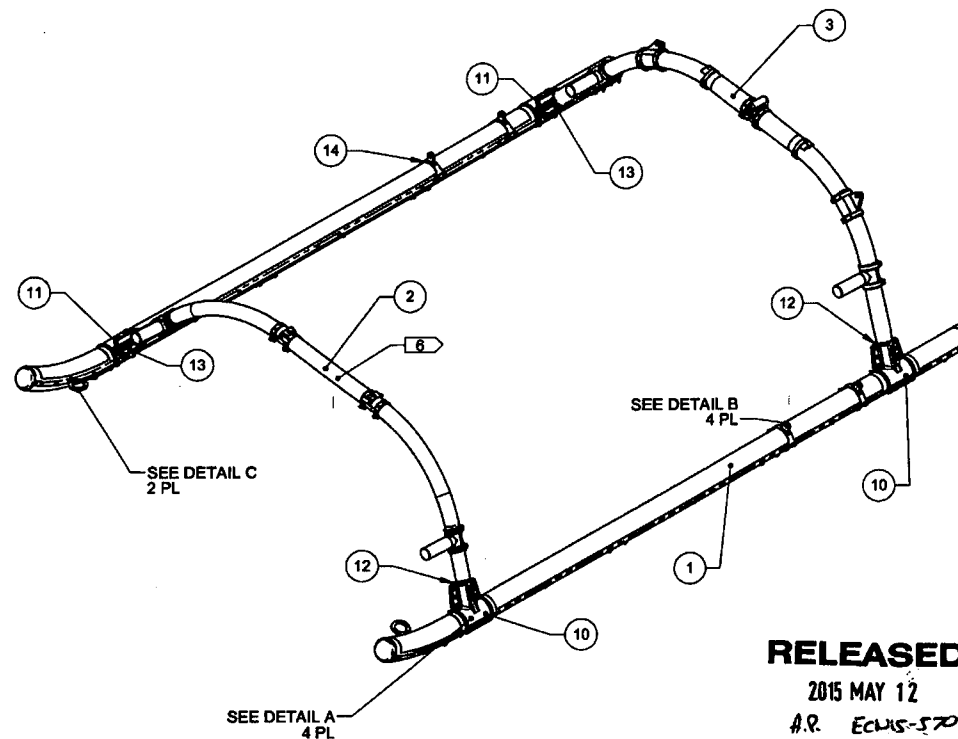
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

ITEM	QTY -021	P/N	DESCRIPTION
	X	D119-796-021	STD GEAR WITH STD WEARPADS
1	2	D119-846-041	STD SKIDTUBE WITH STD WEARPADS
2	1	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
3	1	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
4	48	D2652	BUSHING
5	2	D3407-041	TOW RING
6	4	D3417-5	WASHER
7	2	D3456-1	WASHER
8	48	D3672-3	PHENOLIC WASHER
9	48	D3672-7	PHENOLIC WASHER
10	2	D3883-1	SADDLE, OUTBOARD LH
11	2	D3883-2	SADDLE, OUTBOARD RH
12	2	D3884-1	SADDLE, INBOARD LH
13	2	D3884-2	SADDLE, INBOARD RH
14	4	D3886-041	LUG ASSEMBLY
15	8	AN3C46A	BOLT
16	16	AN3C50A	BOLT
17	24	AN4C8A	BOLT
18	24	MS21043-3	NUT, SELF-LOCKING
19	26	MS21043-4	NUT, SELF-LOCKING
20	8	MS21043-5	NUT, SELF-LOCKING
21	8	MS21250-05048	BOLT
22	24	NAS1149C0332R	WASHER
23	48	NAS1149C0432R	WASHER
24	16	NAS1149C0532R	WASHER



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2015 MAY 12

A.R. ECHUS-STD

D119-796-021 STD GEAR WITH STD WEARPADS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN
- 7) WEIGHT: 122.7 LBS

APPROVED

A NEW ISSUE		AP	15.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

MS21250-05048 BOLT
NAS1149C0532R WASHER
D3672-7 WASHER
2 PL
10

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)

AN3C50A BOLT
D3672-7 WASHER
D2652 BUSHING
4 PL
10

D3884-1 SADDLE (LHS)
D3884-2 SADDLE (RHS)

D3672-7 WASHER
NAS1149C0532R WASHER
MS21043-5 NUT
2 PL
10

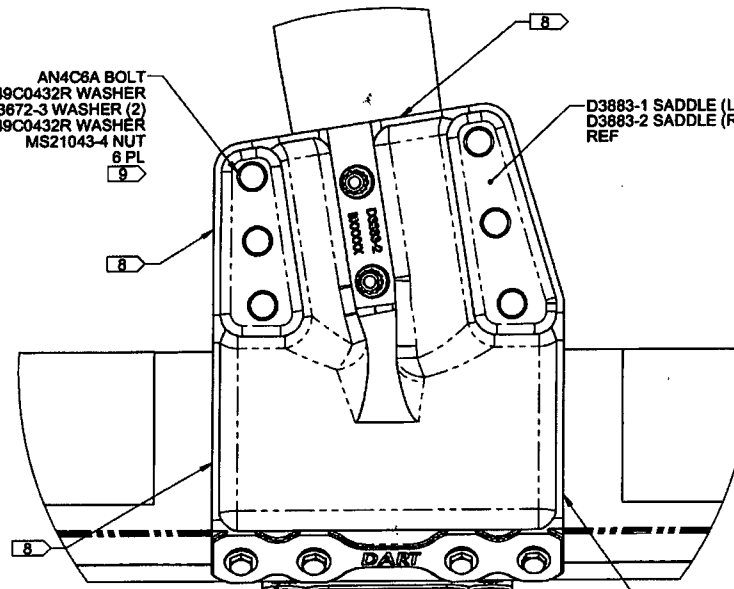
D2652 BUSHING
D3672-7 WASHER
NAS1149C0332R WASHER
MS21043-3 NUT
4 PL
10

DETAIL A
4 PL



AN4C6A BOLT
NAS1149C0432R WASHER
D3672-3 WASHER (2)
NAS1149C0432R WASHER
MS21043-4 NUT
6 PL
9

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)
REF



DETAIL A



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2015 MAY 12

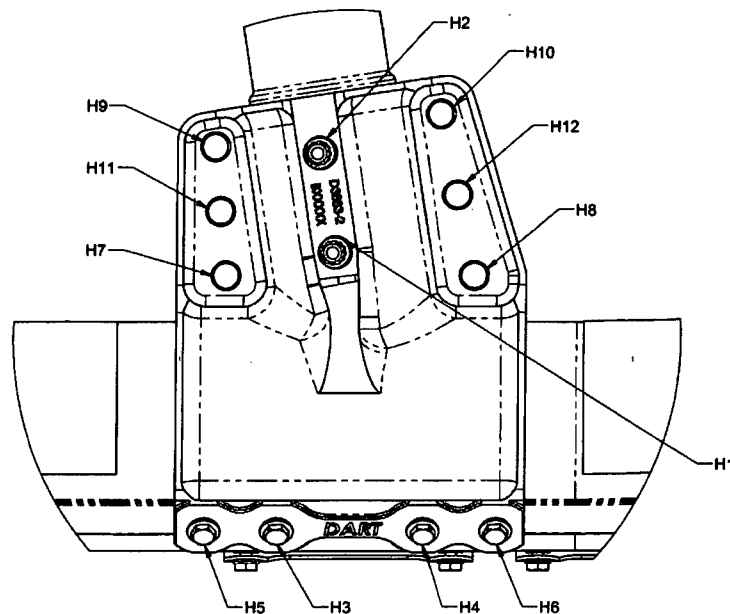
A.P. EN 15-570

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A CONTINUOUS BEAD OF SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT IN THE LOCATIONS SHOWN INCLUDING THE FOLLOWING:
 - A) ALONG SADDLE/CROSSTUBE INTERFACE
 - B) BETWEEN THE SADDLE FLANGES
 - C) ALONG SADDLE/SKIDTUBE INTERFACE
- 9) LIGHTLY TIGHTEN ALL BOLTS IN THE NUMERICAL ORDER SPECIFIED ON SHEET 3, THEN TIGHTEN TO SPECIFIED TORQUE IN TABLE 1.
- 10) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) ALL NUTS TO BE INSTALLED ON THE INBOARD SIDE

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DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)

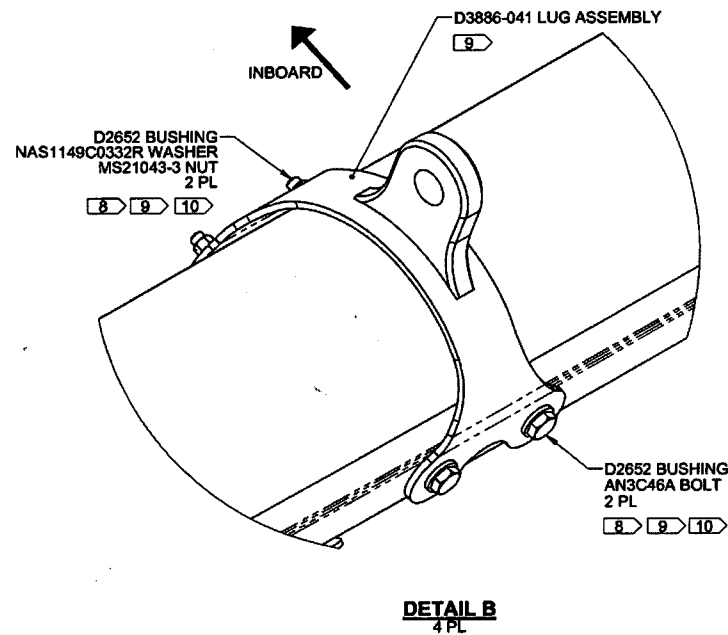
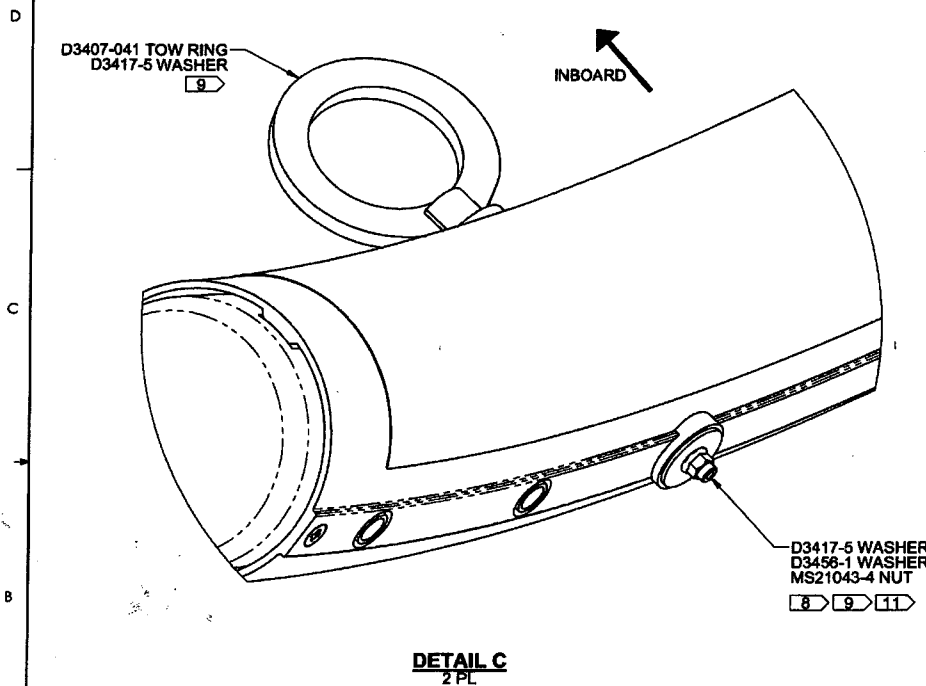
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2015 MAY 12
A.P. EN 15-570

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DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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8 7 6 5 4 3 2 1



RELEASED

2015 MAY 12

A.P. EUN15-570

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) APPLY FAY SEAL AND FILLET SEAL USING SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 10) TORQUE AN3 HARDWARE TO 20-25 IN-LBS
- 11) TORQUE AN4 HARDWARE TO 50-70 IN-LBS

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DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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8 7 6 5 4 3 2 1